

Work Order ID 68801

Thursday, April 21, 2011 7:31:26 AM



Page 1

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 4/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

OK 11/04/27

20

[Signature]

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3
Dwg Rev A Folio Rev AA

OK 11/04/30

20 11.5.2

20

[Signature]

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 11/04/30

20 11.5.2

20

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00 SL 11/05/03



QC Memo

0.00

Quality Control

140 Small Fab

0.00



Small Fab Memo

0.00

Small Fab 1-Deburr □2- C'sink as per Dwg D2873

150 QC5- Inspect part completeness to step on W/O

0.00 S 11/05/03



QC Memo

0.00

Quality Control

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Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

720 6 22 4/25/02

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BR 11-5-3

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 02-Identify as D2873-043

E/S 4/25/03 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Nut Plate Assembly

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Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/05/103

Canto
(120)

200

Identify as per dwg & Stock Location: X-tube

0.00



Packaging

Memo

0.00

Packaging

ASS'y

M 11 05 04 20

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/49

11/11-08-31
(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 7:31:42 AM

Work Order ID: 68801



Parent Item: D2873-043



Parent Item Name: Nut Plate Assembly

Start Date: 4/21/2011

Required Date: 4/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21075L5		Purchased	No			100	Each	46.0000	3	60			
Nut Plate													

Location	Loc Qty	Loc Code
ST303	46	
116914	46	

M6061T6B0.375X01.00 0		Purchased	No			180	f	18.6426	0.3083	6.490526			
6061T6 BAR .375 x 1.00													

Location	Loc Qty	Loc Code
MAT002	18.6426	
116963	18.6426	

MS20426AD4-6		Purchased	No			180	Each	1,204.000	6	120			
Rivet													

Location	Loc Qty	Loc Code
ST317	1204	
110139	1204	

~~20 U.S.2~~

M11 7557
60x
EP 11/05/03
RE U.S.2

6490

~~20 U.S.2~~

120

EP 11/05/03

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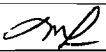

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 68801
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	—		Vern HL-7	
2.000	+/-0.010	1.999	—		"	
0.750	+/-0.010	.750	—		"	
1.000	+/-0.010	1.000	—		"	
0.250	+/-0.010	.250	—		"	
1.000	+/-0.010	1.000	—		"	
2.000	+/-0.010	2.000	—		"	
3.000	+/-0.010	3.000	—		"	
Ø0.128	+0.005/-0.001	Ø.128	—		"	
0.359	+/-0.010	.360	—		"	
Ø0.316	+0.006/-0.001	Ø.317	—		"	
1.000	+/-0.010	1.005	—		"	
0.250	+/-0.010	.257	—		"	
0.061	+/-0.010	.064	—		"	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .123	—		"	

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/04/20	Date: 11/05/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM 	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

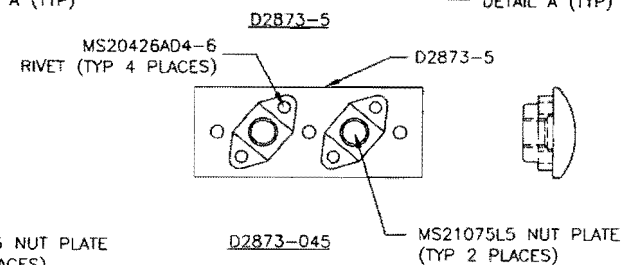
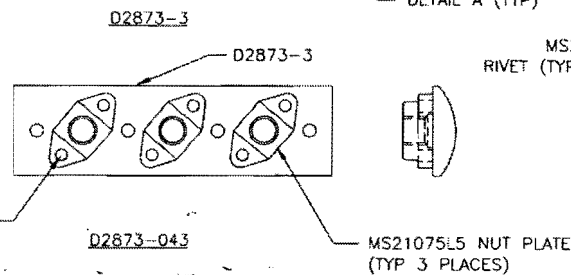
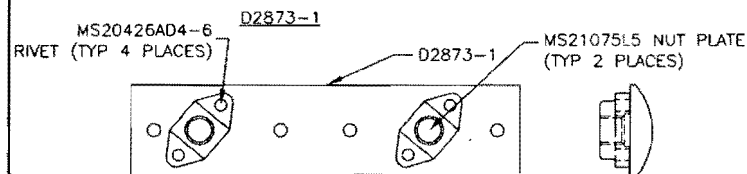
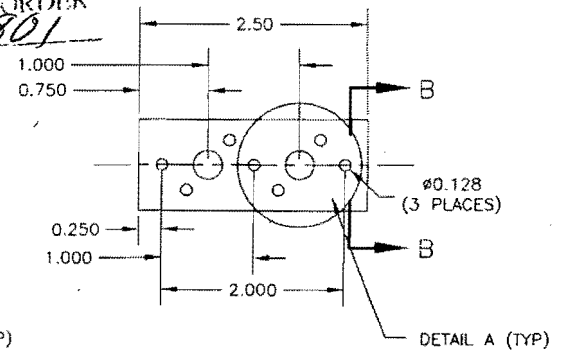
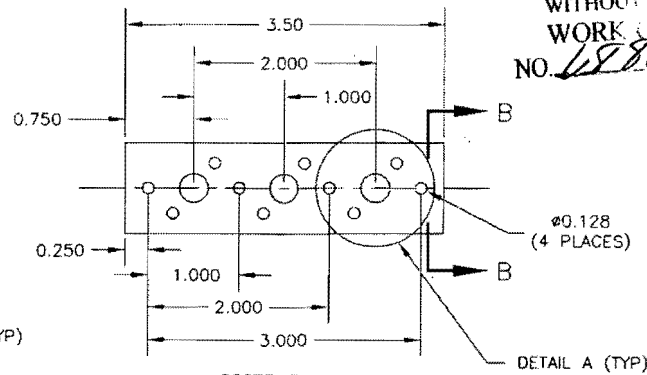
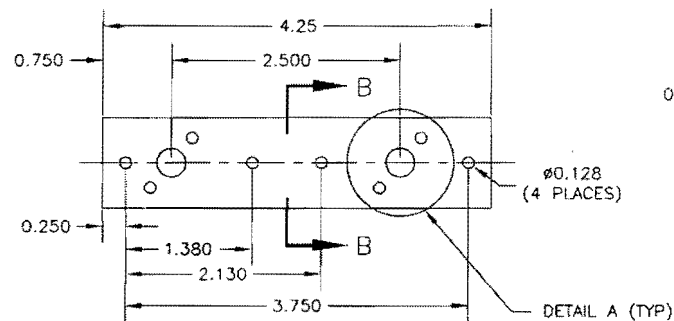
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

11-04-21

WITHOUT NOTICE
WORK ORDER
NO. 18801

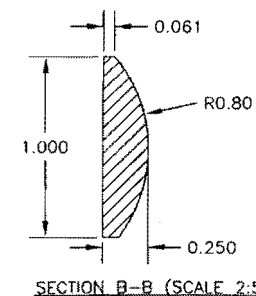
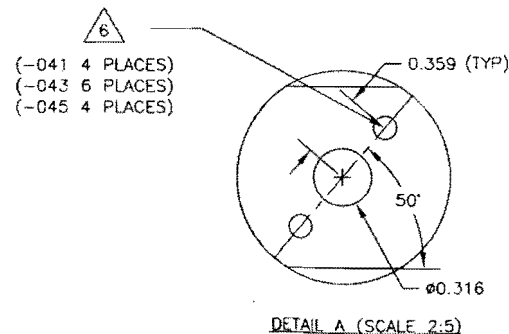


- D2873-1/-3/-5 RADIUS BLOCK**
- MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
 - FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - ALL DIMENSIONS ARE INCHES
 - BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 0.128 PILOT + C'BORE CURVED SIDE 0.230X0.125 DEEP + C'SINK CURVED SIDE 0.225 x 100'

- D2873-041/-043/-045 NUT PLATE ASSEMBLY**
- INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5

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